

Date: Wednesday, 3/12/2008 2:00:57 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	37898	Part Number	D353525
Estimate Number	12734	Drawing Number	D3535 REV B
P.O. Number		Project Number	N/A
This Issue	3/12/2008	Drawing Revision	B
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	3/24/2008
Previous Run	36424	Qty:	4
Written By	108 03 12		
Checked & Approved By			
Comment	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 0.5355 sf(s)/Unit Total : 2.1420 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 106748 1B 8-3-17		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B 1B 8-3-17 Prog Rev: B		
2-Deburr if necessary 1B 8-3-17		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-3-17		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 108/03/18 (4)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 SB 08/03/18 (4)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 28/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 2:00:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37898

Part Number: D353525

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



8 08/03/18 (X4)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING



M 106442



(X4)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 08/03/18

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18

(X4)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

08-03-18

(X4)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/18

Job Completion



2008/3/18

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

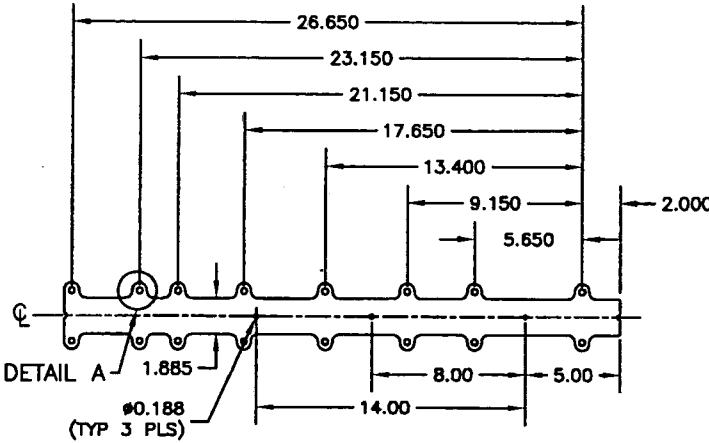
DART AEROSPACE LTD	Work Order:	37898
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

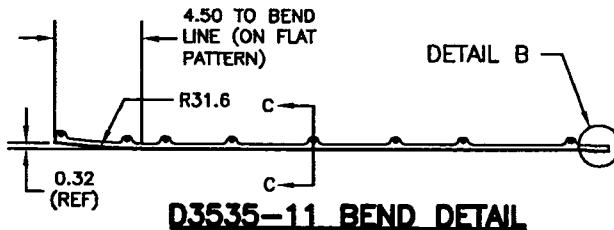
X First Article Prototype

Measured by:	BR	Audited by:	AS	Prototype Approval:	N/A
Date:	8-3-17	Date:	08/03/18	Date:	N/A

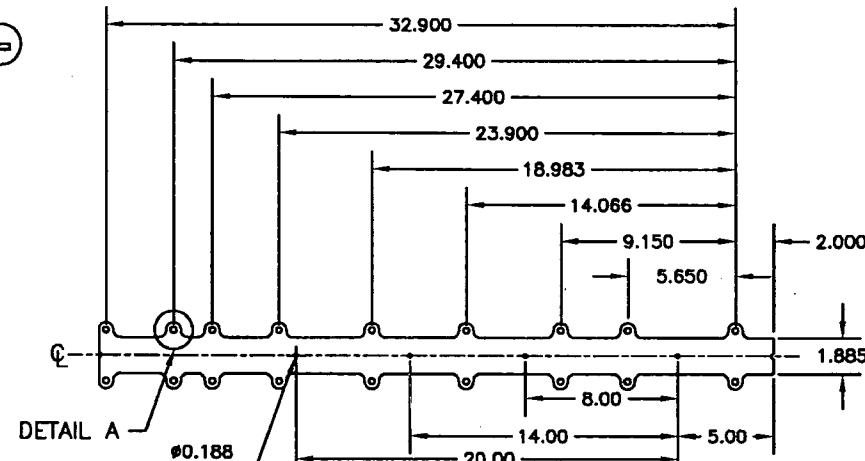
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	



D3535-11F FLAT PATTERN



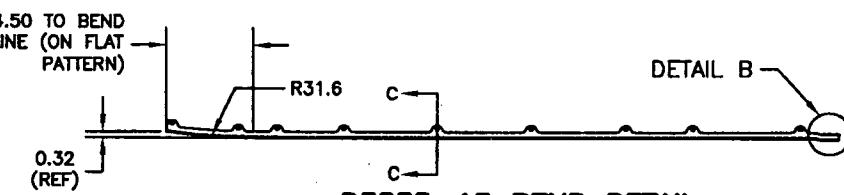
D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



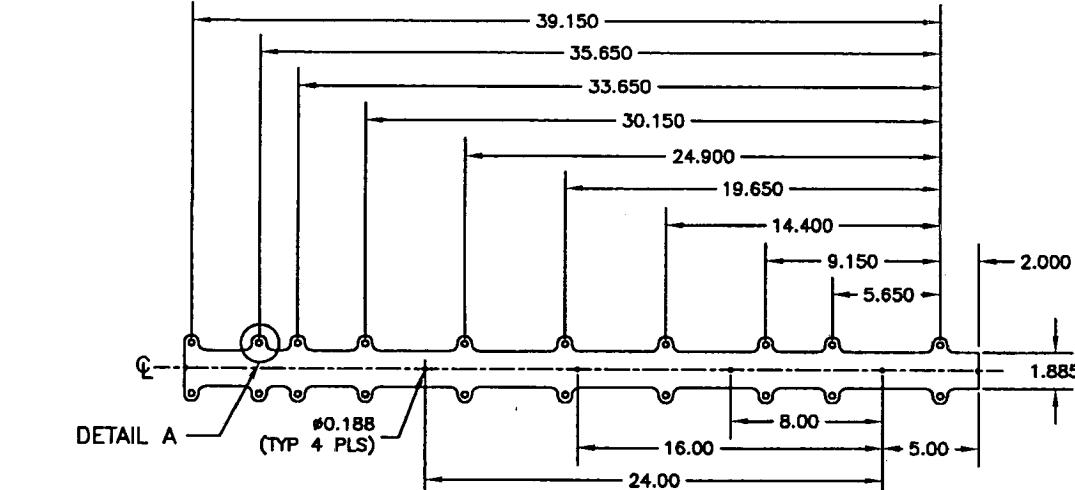
D3535-13 BEND DETAIL

DART

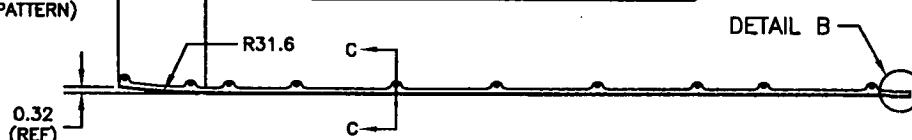
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C8	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



D3535-15F FLAT PATTERN



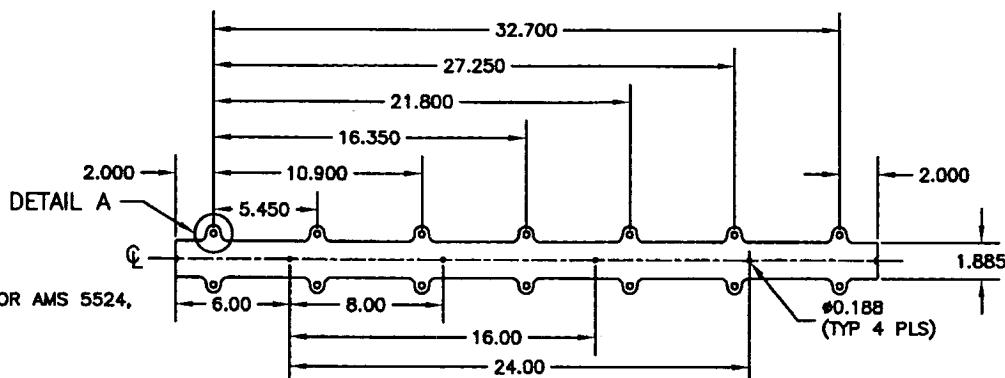
D3535-15 BEND DETAIL

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 QSI 005 4.3

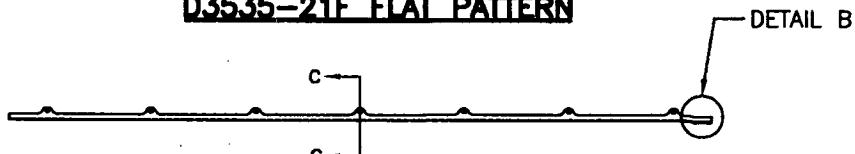
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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D3535-21F FLAT PATTERN

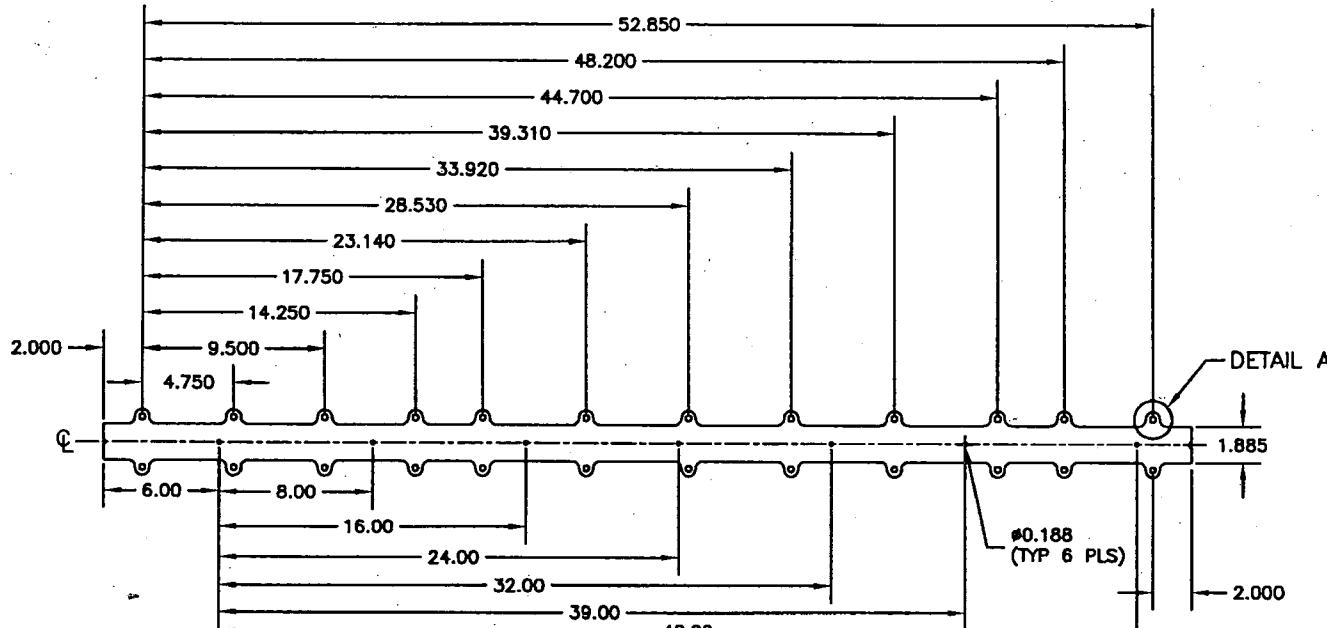


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MM	MM	D3535	
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07.04.17		WEARSHOE	1:10

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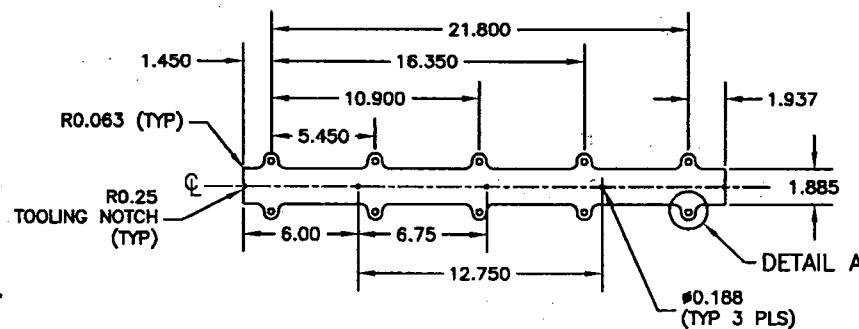


D3535-23 BEND DETAIL

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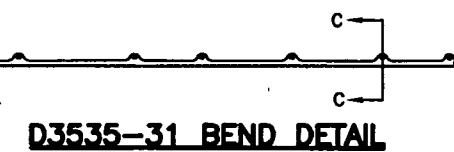
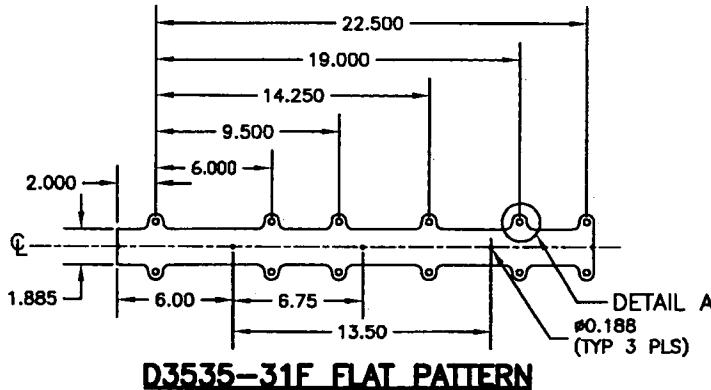
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-25 BEND DETAIL

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MM	MM	D3535
07.04.17		WEARSHOE
DATE		SCALE
		1:10
		REV. B
		SHEET 3 OF 7

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07.04.17

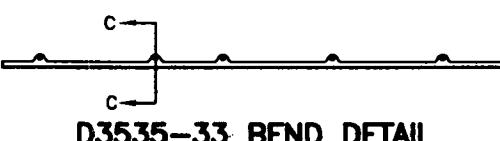
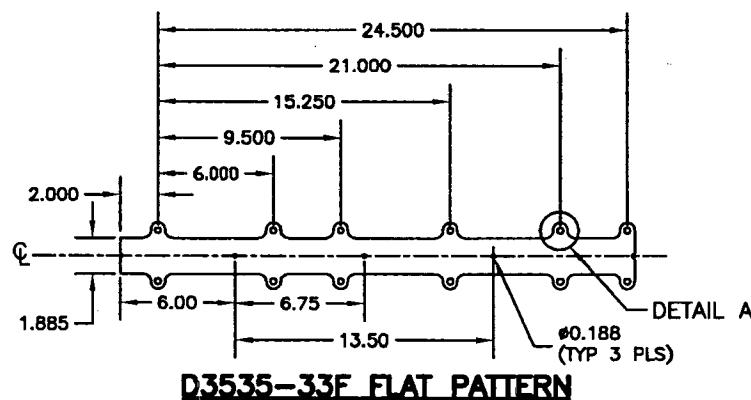
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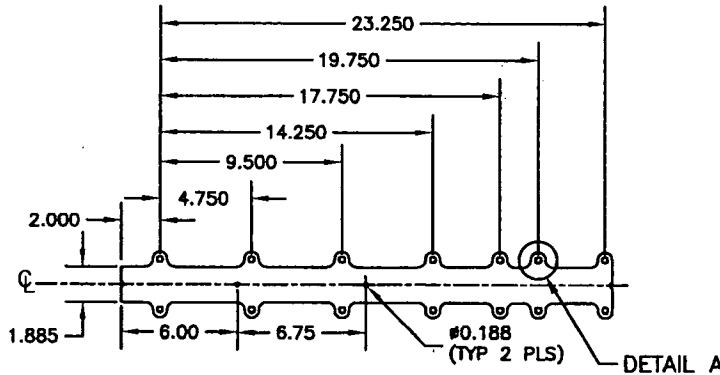
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (.038 THICK) (REF DART SPEC M304520GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	



D3535-35F FLAT PATTERN

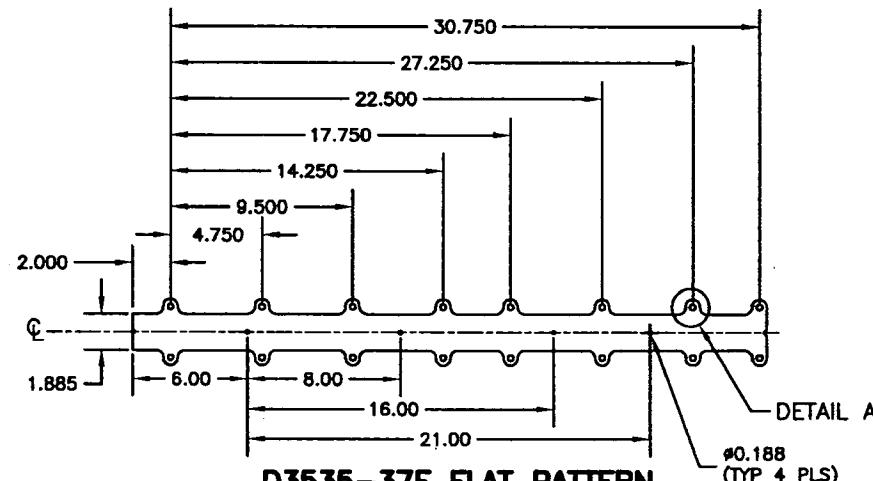


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D3535-37F FLAT PATTERN

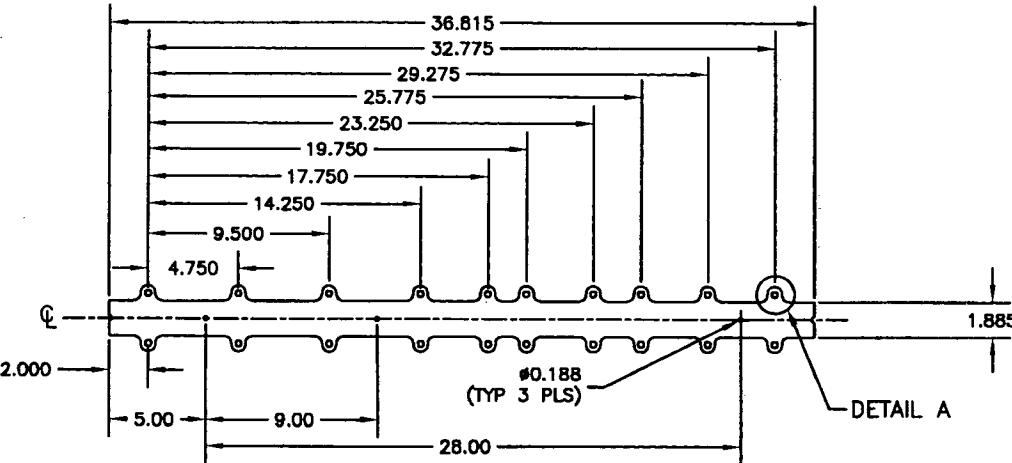


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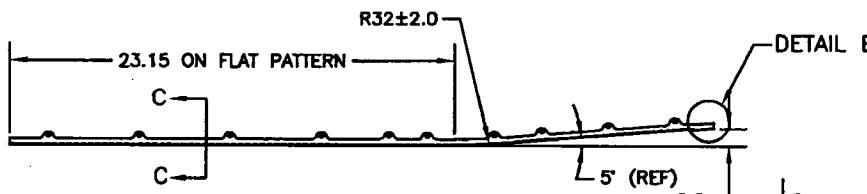
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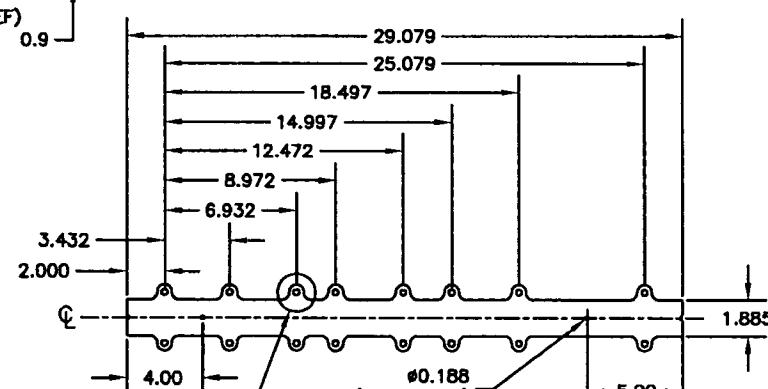
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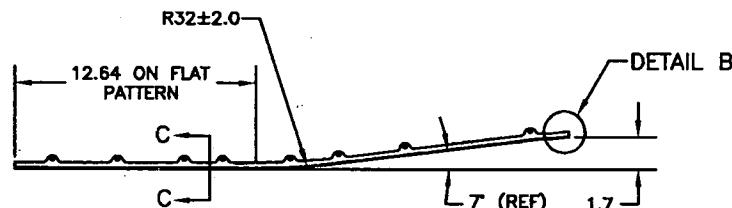
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NOTES
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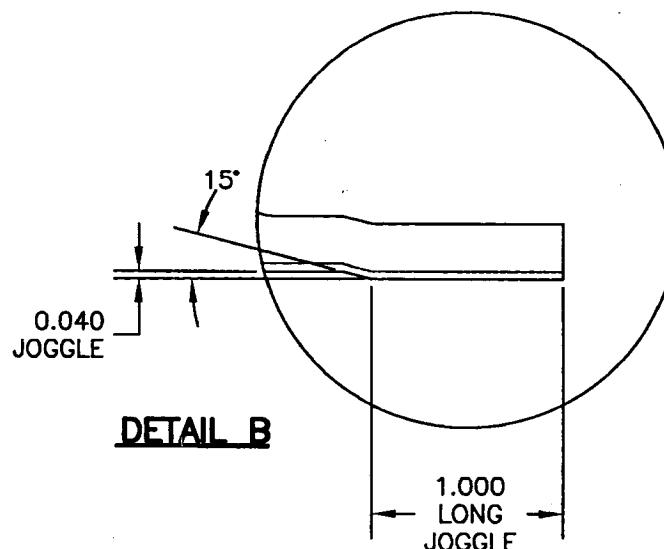
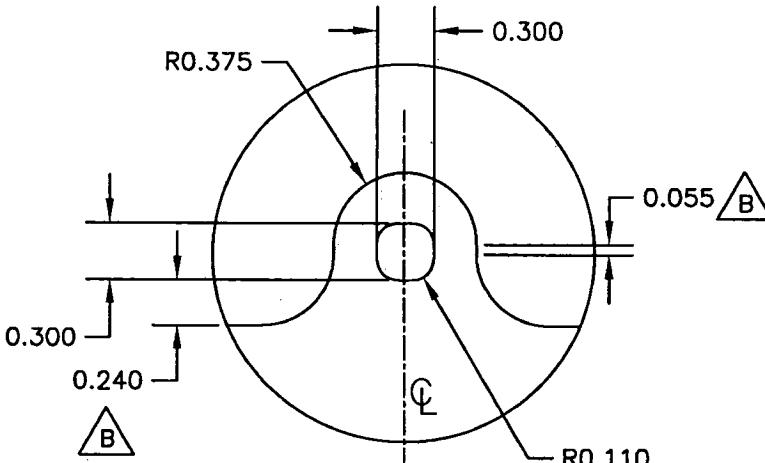
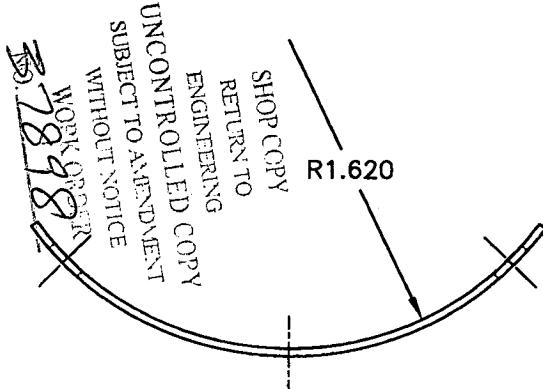
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DATE		TITLE
07.04.17		WEARSHOE
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07.04.24

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		WEARSHOE	1:1

**DETAIL B****DETAIL A****SECTION C-C**

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